

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005040**Date Inspected:** 04-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Fabrication				

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Heavy Bay #2

ABF QC representative Mr. Fu Yuhong informed the QA Inspector that ZPMC has completed final visual, magnetic particle and ultrasonic (UT) inspections of all tower lift 2 stiffener welds on east tower skin plate A. The QA Inspector assisted QA Inspector Mr. Roberto Medina in performing magnetic particle inspections of welds ESD1-SA300D/F-14, -30, -32; ESD1-SA300D/F-14, -30, and -32. See Mr. Medina's TL-6028 Magnetic Particle Test Report for additional information. The QA Inspector performed random visual inspections of approximately 40% of the welds and the QA Inspector observed five areas that do not comply with project specifications. The QA Inspector also observed ZPMC QC appears to have marked several additional areas as needing to be welded and grinding and these areas do not appear to have been reworked. Mr. Fu Yuhong informed the QA Inspector that ZPMC QC will perform an additional visual inspection of these welds, and that following completion of the rework that he will request an additional inspection by Caltrans QA Inspection personnel.

Summary of Conversations:

See above.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
